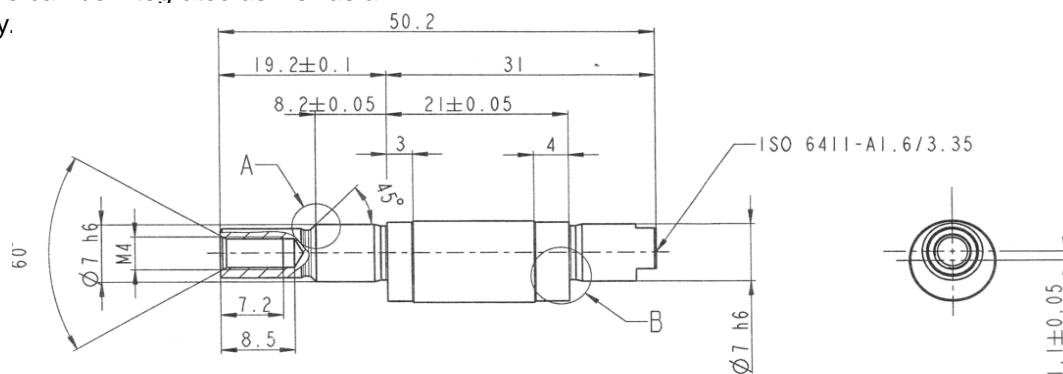


Eccentric shaft Ø7 Ø10 Ø7

A20-200

The plunge pregrinding of the 2 cylindrical diameters and the excenter is done in spiral plunging with a CBN wheel. The diameters are then being finished with a vitrified wheel oscillating. A dressing cycle can be integrated as well as a probing cycle, if necessary.



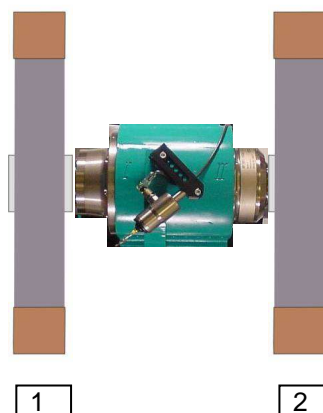
1. Cycletime for Production

Workpiece: Ø7 H6 Ø10 B4 Ø7 H6 Material HSS									
Operations									
Probe D	2000	2000	2000	2000	150	3000	3000	3000	9000
Feed [mm/Min]	2000	2000	2000	2000	150	3000	3000	3000	9000
Power [kW]		4	3	2	2	2	3	2	1
Cutting speed [m/s]		38	38	38	30	38	38	38	
Used wheels									
Grinding time [s]	23	40	40	50	30	30	30	40	20
Total cycle time	5 Min 2								

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø250 CBN125 B20
2	1A1 Ø250 C80-120 B20



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 31iA5 Software: Quinto 5
Accessories: STL6056, Dress, A-Rapid

Responsible engineer: OP, 11.03.12

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